

Work Order ID 67174

Wednesday, March 09, 2011 12:57:55 PM



Page 1

Item ID: D900-619-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 3/9/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: PL Date: 11-03-9

Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D900-619	A

100 0.00



DC

Memo

0.00

5/11/03/22

Handwritten signature BG 11-3-22 (2)

Document Control

Photocopy bluefile & type labels per PPP D900-619-011
CHG003

110 0.00



Packaging

Pick Kit

Memo

0.00

Handwritten signature 11/3/22 SP (20)

Packaging

120 0.00



QC

QC4- 100% Inspect kits for completeness

Memo

0.00

5/11/03/22

Handwritten signature (12)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging		0.00							
Packaging	Memo Identify and pack for shipping as per PPP D900-619-011 Location: <u>11</u> PPP rev: <u>A</u>	0.00							
140 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

6/3/2011 20

11/3/23

MF
11-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 67174

Parent Item: D900-619-011

Parent Item Name: Bearpaw

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP .C04.02.17 Blank size changed on Step 3 KJ/JLM
IPP Rev:D Was k10010 07-01-03 JLM
IPP Rev:E New Manufacturing Method 08-11-04 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A



Bolt

Purchased No

110

Each

330.0000

8

16



11/3/22

Location

Loc Qty

Loc Code

ST308

316

116786

316

76

ST358

14

114784

9

115108

5

AN960JD416



Washer

NAS1149D0463J

Purchased

No

110

Each

30.0000

8

16



11/7/065

11/3/22

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

D2182B



Rubber Cushion

Manufactured

No

110

f

461.3681

2

4



11/3/22

Location

Loc Qty

Loc Code

ST410

461.36811

63413

111.36811

66063

350

(D2182B060) cut 4" at 6.00" as per dwg per kit

2 measured
8 units

52

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 67174

Parent Item: D900-619-011

Parent Item Name: Bearpaw

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 2.00

Required Qty: 2.00

D2274
Radius Block

Manufactured No

110 Each

484.0000

8 16
11/3/22

Location

Loc Qty

Loc Code

ST010

484

61361

1

63990

6

65562

104

65757

250

66123

123

Manufactured No

110 Each

2.0000

2 4
67175

Location

Loc Qty

Loc Code

ST496

2

60444

2

Manufactured No

110 Each

79.0000

4 8
11/3/22

Location

Loc Qty

Loc Code

ST456

29

62078

29

ST462

50

65118

50

Manufactured No

110 Each

982.0000

8 16
11/3/22

Location

Loc Qty

Loc Code

ST016

982

64127

482

66953

500

16

D2519
Clamp

D2529
Washer

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Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Wednesday, March 09, 2011 12:58:02 PM

Work Order ID: 67174

Parent Item: D900-619-011

Parent Item Name: Bearpaw

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

110

Each

4,376.000



8 16
11/13/22

Nut

Location

Loc Qty

Loc Code

ST300

4376

1123143

2

115589

10

115621

20

116188

2344

116823

2000

QS100-M24S

Purchased

No

110

Each

25.0000



4 8
11/13/22

Clamp

Location

Loc Qty

Loc Code

ST449

25

116169

2

116391

3

116513

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

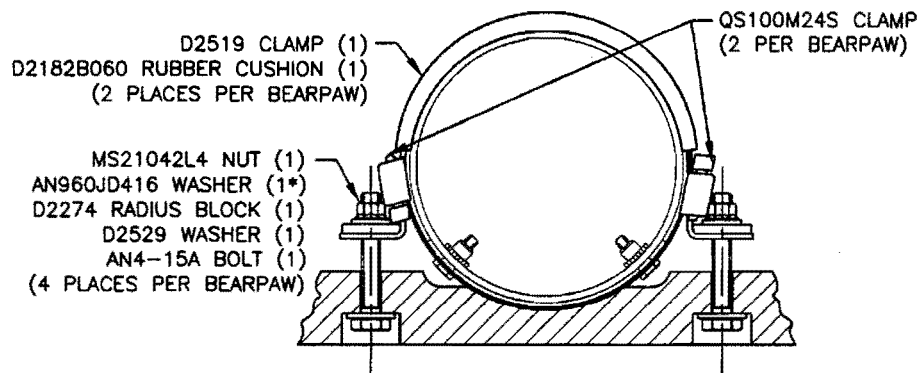
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY



* See note 6

Figure 32-2: Bearpaw Installation (section view)

6. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
7. Lower the aircraft

32.2 BEARPAW REMOVAL

1. Jack up the aircraft.
2. Loosen the clamp bolts and remove the bearpaws and clamps. Ensure the skid tubes are serviceable.
3. Lower the aircraft.

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D900-619-011 Bearpaw Installation	13.8 lb 6.3 kg	0.0 in 0.0 m	0.0 lb-k 0.0 m-k	233.3 in 5.93 m	3220 in-lb 37.4 m-k

32.4 PARTS LIST

Qty	Part Number	Description
X	D900-619-011	BEARPAW INSTALLATION
4	D2182B060	RUBBER CUSHION
8	D2274	RADIUS BLOCK
2	D2421	BEARPAW
4	D2519	CLAMP
8	D2529	WASHER
8	AN4-15A	BOLT
8	AN960JD416	WASHER
8	MS21042L4	NUT (OR MS21042-4)
4	QS100M24S	CLAMP

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32-00-00